

Work Order ID 60345

July 6, 2010 11:32:43 AM

slip July 9 Rush

Page 1

Item ID: D2174-041

Accept



Setup Start



Revision ID:

Item Name: Web, 205

Stop



Start Date: 7/06/10

Start Qty: ~~4.00~~ 6



Cust Item ID:

Required Date: 7/08/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *N*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2174

Rev E

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D2174-041 2- Identify as D2174-041

8/5/07/08 (6)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/07/08

(+6)

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:00

OVEN TEMPERATURE:

320°

FINISH TIME:

8:30

(6) BL 10-7-8.

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Item ID: D2174-041

Accept

Revision ID:

Item Name: Web, 205

Start Date: 7/06/10 Start Qty: 4.00

Required Date: 7/08/10 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install nuts & bolts loosely as per Dwg D2174

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



Handwritten notes: 10/07/07 X6 0

Handwritten notes: 8/00/09/08 (6)

Handwritten notes: 8/06/08

Handwritten notes: (6)

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Item ID: D2174-041

Accept

Revision ID:

Item Name: Web, 205

Start Date: 7/06/10 Start Qty: 4.00

Required Date: 7/08/10 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 199

0.00



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

← 1007-08
MF
10-7-8

Picklist Print

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Work Order ID: 60345

Parent Item: D2174-041

Parent Item Name: Web. 205



Start Date: 7/06/10

Required Date: 7/08/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D 04.06.10 Reformat: Changed Step 2: KJ/JLM
IPP Rev:E As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN526C832R14		Purchased	No			140	Each	668.0000	4	16			
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Screw

Location

Loc Qty

Loc Code

ST327

668

104916

668

AN960JD8	NAS1149DN832	Purchased	No			140	Each	0.0000	4	16			
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Washer

D2174-1		Manufactured	No			100	Each	7.0000	1	4			
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Web

Location

Loc Qty

Loc Code

GA

7

50234

4

59526

3

D2175-1		Manufactured	No			100	Each	0.0000	1	4			
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Angle LH

D2175-2		Manufactured	No			100	Each	6.0000	1	4			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Angle RH

Location

Loc Qty

Loc Code

GA

6

58422

6

10-7-8

16

16

M114740 10-7-88

9/5/07/08

3

3

3

6 9/5/07/08

9/5/07/08

6

Picklist Print

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Work Order ID: 60345

Parent Item: D2174-041

Parent Item Name: Web, 205



Start Date: 7/06/10

Required Date: 7/08/10

Start Qty: 4.00

Required Qty: 4.00

MS20470AD4-6 Purchased No



Rivet, Universal Head

140 Each 1,771.000 19 76



EP 10/07/08

Location

Loc Qty

Loc Code

ST320

1771

113644

255

114905

1

114988

1515

114

MS21042L08

Purchased

No



Nut

100 Each

367.0000 4



16 2x 10-7-8 SP 41

Location

Loc Qty

Loc Code

ST300

367

114330

167

115016

200

16

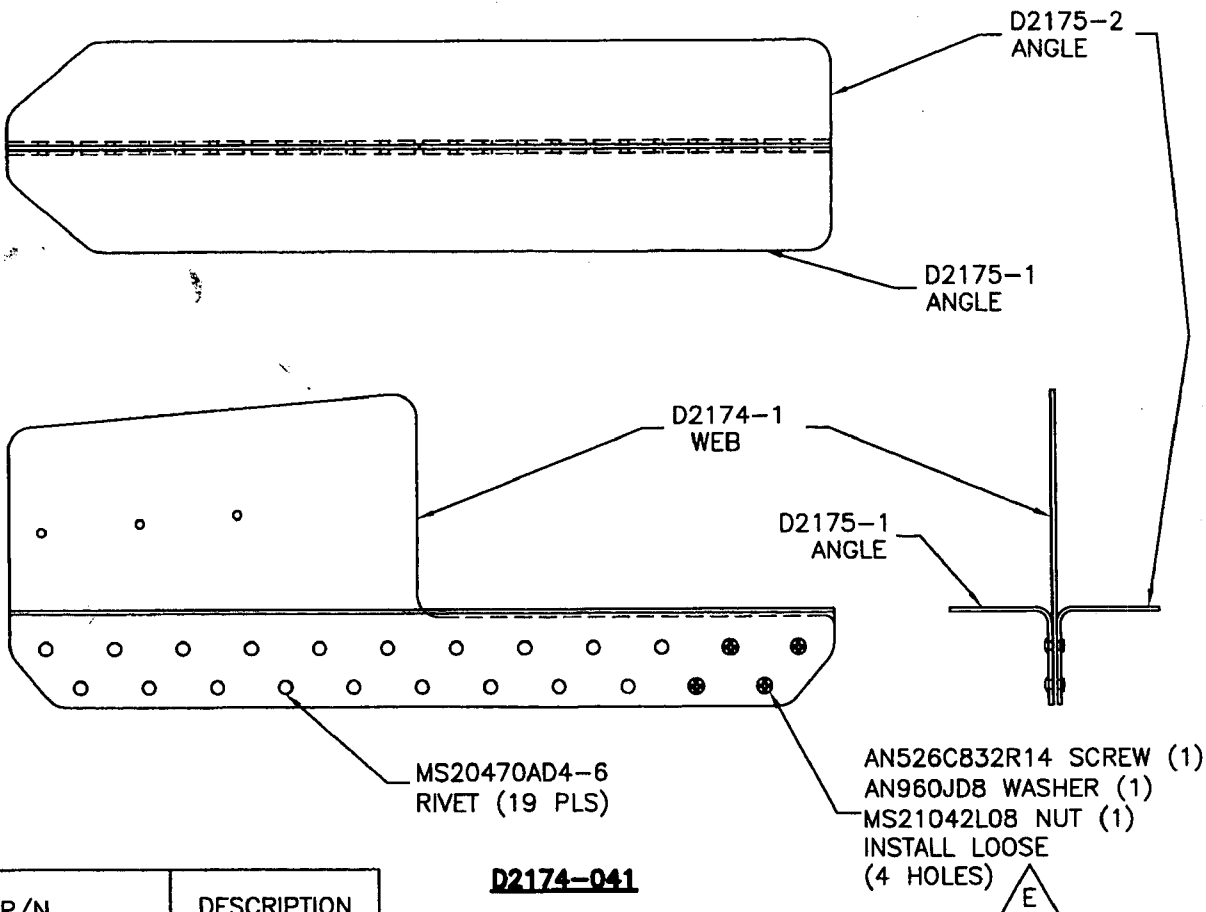
July 6, 2010 11:32:41 AM

Shop Packet Print

Page 2

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
RF	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2174	SHEET 1 OF 2
DATE 06.09.25		TITLE WEB ASSEMBLY	SCALE 1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



D2174-041

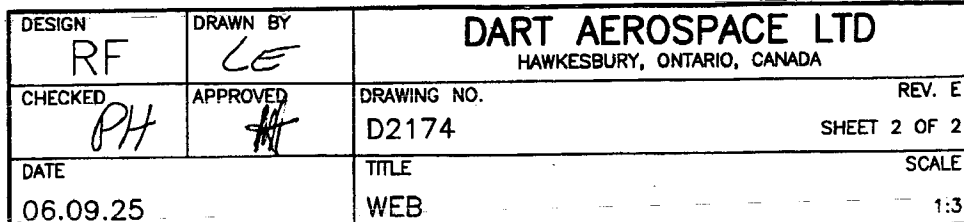
ilo 60345

RELEASED
06.10.13

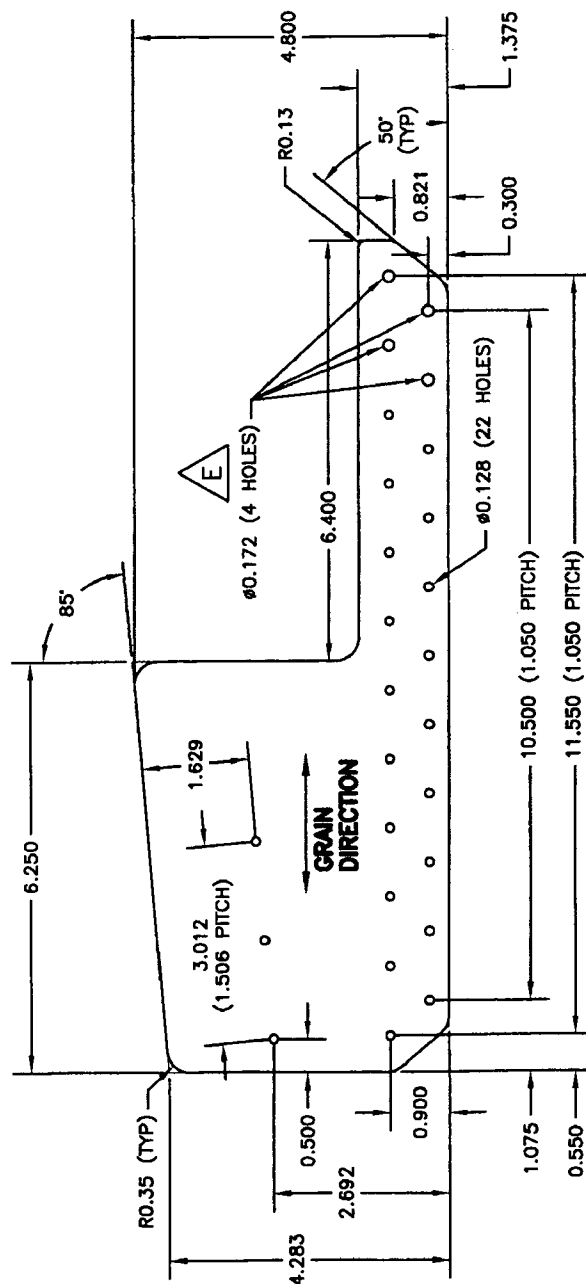
QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.



RELEASE
06.10.3



D2174-1

NOTES:

- NOTES:
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) ALL DIMENSION ARE IN INCHES

50345

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